

**WHAT IS CLAIMED IS:**

1. Composite colorant polymer particles having a colorant phase and a polymer phase, said polymer phase of said particles being formed in the presence of said colorant in situ using an emulsion polymerization process  
 5 wherein a portion of an addition polymerization initiator consisting essentially of an initiator dissolved in a solvent is added to an aqueous colorant mixture before adding a monomer mixture to the colorant mixture in a continuous process, the dispersion of composite colorant polymer particles being stable as defined by said particles not flocculating for up to 20 minutes when a dispersion containing said  
 10 particles is added to acetone at a 1% by weight concentration; wherein the colorant mixture consists essentially of a colorant, a dispersant or surfactant and water.

2. The composite colorant polymer particles of Claim 1 wherein said colorant phase comprises a pigment.

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3. The composite colorant polymer particles of Claim 1 wherein said polymer phase comprises a polymer formed from methyl methacrylate, ethyl methacrylate, butyl methacrylate, ethyl acrylate, butyl acrylate, hexyl acrylate, n-octyl acrylate, lauryl methacrylate, 2-ethylhexyl methacrylate, nonyl acrylate,  
 20 benzyl methacrylate, 2-hydroxypropyl methacrylate, acrylonitrile, methacrylonitrile, vinyl acetate, vinyl propionate, vinylidene chloride, vinyl chloride, styrene, t-butyl styrene, vinyl toluene, butadiene, isoprene, N,N-dimethyl acrylamide, acrylic acid, methacrylic acid, chloromethacrylic acid, maleic acid, allylamine, N,N-diethylallylamine, vinyl sulfonamide, sodium acrylate, sodium  
 25 methacrylate, ammonium acrylate, ammonium methacrylate, acrylamidopropane-triethylammonium chloride, methacrylamidopropane-triethylammonium chloride, vinyl-pyridine hydrochloride, sodium vinyl phosphonate and sodium 1-methylvinylphosphonate, sodium vinyl sulfonate, sodium 1-methylvinyl-sulfonate or sodium styrenesulfonate.

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4. The composite colorant polymer particles of Claim 1 having a mean particle size of less than about 200 nm.

5. The composite colorant polymer particles of Claim 1 having a mean particle size of less than about 80 nm.

6. The composite colorant polymer particles of Claim 1 wherein  
5 said polymer phase is cross-linked.

7. The composite colorant polymer particles of Claim 1 wherein  
said colorant phase of said composite colorant particles has a mean size of less  
than about 80 nm and said polymer phase has a molecular weight of greater than  
10 about 5000.

8. The composite colorant polymer particles of Claim 1 wherein  
said polymer phase has a molecular weight of greater than about 10,000.

9. The composite colorant polymer particles of Claim 1 wherein  
15 the ratio of said colorant phase to said polymer phase is from about 30:70 to about  
70:30.